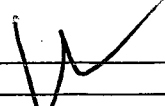



Date: Thursday, 15/03/2007 11:50:10 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOAT SKID LH 206L1,L3,L4&407
<b>Job Number</b> : 24793	
<b>Estimate Number</b> : 10307	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206642511
<b>This Issue</b> : 15/03/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 18/11/2005 <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : 23131	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 20/12/2005 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-511CHG002 ← CHG 002 OK'd 07.03.15

2.0	24793A	FLOAT SKIDTUBE ASSEMBLY
-----	--------	-------------------------



24793



**Comment:** Sub-Component FLOAT SKIDTUBE ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

MF. 07-03-15

4.0	D206648013	GHW Kit
-----	------------	---------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
-----------------	-------------	-------

1 D206-648-013	GHW Kit	B 24580 ✓
----------------	---------	-----------

5.0	D2652	Bushing
-----	-------	---------



**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
-----------------	-------------	-------

16 D2652	Bushing	B 29227 ✓
----------	---------	-----------

MF 07-03-15

Date: Thursday, 15/03/2007 11:50:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24793

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

B 26481 ✓

7.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

B 28668 ✓

8.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

B 30486 ✓

9.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B 29345 ✓

10.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B 29346 ✓

11.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

B 29347 ✓

MF. 07-03-15

Date: Thursday, 15/03/2007 11:50:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24793

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

B 28922 ✓

13.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

B 24583 ✓

14.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

B 24868 ✓

15.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

B 25701 ✓

16.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

B 24585 ✓

17.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

M 18918 ✓

ME. 07-03-15

Date: Thursday, 15/03/2007 11:50:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24793

Part Number: D206642511

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0 AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
-----------------	-------------	-------

9 AN3C36A	Bolt	M18918 ✓
-----------	------	----------

19.0 AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
-----------------	-------------	-------

8 AN3C41A	Bolt	M18918 ✓
-----------	------	----------

20.0 AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
-----------------	-------------	-------

12 AN4C6A	Bolt	M101418 ✓
-----------	------	-----------

21.0 AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
-----------------	-------------	-------

8 AN5C11A	Bolt	M18918 ✓
-----------	------	----------

22.0 AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
-----------------	-------------	-------

4 AN5C12A	Bolt	M18918 ✓
-----------	------	----------

23.0 AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
-----------------	-------------	-------

4 AN5C13A	Bolt	M18918 ✓
-----------	------	----------

MF. 07-03-15

Date: Thursday, 15/03/2007 11:50:11 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24793

Part Number: D206642511

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

24.0	AN5C15A	Bolt
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 AN5C15A	Bolt	m100229 ✓

25.0	AN5C32A	
------	---------	--



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 AN5C32A	Bolt	m18918 ✓

26.0	AN5C34A	
------	---------	--



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 AN5C34A	Bolt	m18918 ✓

27.0	AN5C35A	
------	---------	--



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 AN5C35A	Bolt	m18918 ✓

28.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
24 AN960C10L	Washer	m102602 ✓

29.0	AN960C416L	WASHER
------	------------	--------



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
24 AN960C416L	Washer	m100651 -

MF. 07-03-15

Date: Thursday, 15/03/2007 11:50:11 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24793

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer M18918 ✓

31.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut M102115 ✓

32.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut M102959 ✓

33.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut M18535 ✓

34.0

NAS1515H3L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H3L

Washer M103325 ✓

YMF-0703-15

Date: Thursday, 15/03/2007 11:50:11 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24793

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer

m103338 ✓

36.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H5

Washer

m101064 ✓

37.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H5L

Washer

m100680 ✓

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-511

Location: B

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W 07/03/09

□□□□□□□□

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	: 0024793	Department Code:	
Project Name	: D206-642-511	Burden Flags	: NNNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *D206-642-511	Invoice Number	:
Description	: Float Skidtube LH	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 1	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-20-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



Date: Friday, 11/18/2005 1:48:58 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FLOAT SKIDTUBE ASSEMBLY
<b>Job Number</b>	: 24793A		
<b>Estimate Number</b>	: 10309		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206642541
<b>This Issue</b>	: 11/18/2005	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3274 REV C
<b>First Issue</b>	: / /	<b>Project Number</b>	:
<b>Previous Run</b>	: 23132	<b>Drawing Revision</b>	: C
		<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 12/20/2005
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	1
<b>Comment</b>	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D26001240	Extrusion Round 3" 206
-----	-----------	------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-240 3" OD Tube

B10427 DP05-11-23

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

DP05-11-23

2-Drill #40 Aft cap pilot hole using DT8025

DP05-11-23

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

DP05-11-23

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

DP05-11-23

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP05-11-23

6-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

Pmc 05-11-28

7-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

Pmc 05-11-28

8-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

Pmc 05-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 11/18/2005 1:48:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24793A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

*A.M 05-11-24*

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BE 06-01-23*

5.0	D3282041	I-Beam
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web *B 24862 a.m 06-01-16*

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291 *M19134*

Sikaflex expire date: *06-01-16 a.m 06-01-16*

Start: *06-01-16* Time: *2:30*

Finish: *06-01-23* Time: *3:10 a.m 06-01-23* ①

(Adhere for 12 hours)

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to *POG-1 ①*  
maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274 *DP06-1-23 ①*

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274 *BE 06-1-24 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 1:48:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24793A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for wearplates using D3274-1T2, then open to Ø0.297". (without cutting fluid)

BE 06-1-24 ①

5-Deburr

BE 06-1-24 ①

6-C'sink cross bolt holes as per Dwg D3274

BE 06-01-25 ①

9.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1 Fwd Cap

B21744

BE 06-01-25 ①

10.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D2649 Crossbolt spacer

B24200

BE 06-01-25 ①

11.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

B24861

BE 06-01-25 ①

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod

m15855

m19100

BE 06-01-25 ①

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

m15855

m19100

BE 06-01-25 ①

3-Grind welds flush to Fwd cap on top surface only.

DP 06-1-25 ①

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

DP 06-1-25 ①

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

DP 06-02-01 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval - Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 1:48:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24793A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

0059

WELD INSPECTION



Weld and Counterbore. Inspect for foreign objects as per QSI 024

PD 06-02-02 / 06-02-06

COATING

POWDER COATING



POWDER COATING

Welder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS/AM 07-03-05

INSPECT POWDER COAT/CHEMICAL CONVERSION



INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 07/03/05

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate B24251

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet M103525

18.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet M15918

AM 07/03/05

W/O: \_\_\_\_\_

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries



Date: Friday, 11/18/2005 1:48:59 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24793A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D26483

Wearpad



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 D2648-3

Wearpad

B29777

20.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B21712

21.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B29336

22.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-35

Wearshoe

B29337

23.0

D32871

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3287-1

Wearshoe

B21719

24.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B30237

FAL

07/03/06 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 1:48:59 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24793A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

25.0	AN960C10L	Inventory
------	-----------	-----------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	AN960C10L	Washer	M103344

26.0	MS27039C108	SCREW
------	-------------	-------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	MS27039C1-08Screw		M19185

27.0	NAS1330C3KB116	Insert
------	----------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	NAS1330C3KB116 Inserts	(24) 19349	(54)x M103278

28.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	NAS1515H3L Washer	M103481 (61x)	M103641 (17x)

29.0	D34131	RING
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3413-1	Ring	B24869

30.0	AN4C5A	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C5A	Bolt	M18918

SR/ 07/03/06 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 11/18/2005 1:48:59 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24793A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN960C416L

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960C416L

Washer

M 18822

32.0

NAS1515H4L

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 NAS1515H4L

Washer

M 01542

33.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B 30119

34.0

AN960C10L

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960C10L

Washer

M 103344

35.0

MS27039C108

SCREW



Comment: Qty.: ~~12.0000~~ Each(s)/Unit Total : ~~12.0000~~ Each(s)

Pick: 2.0

2.0

Qty Part Number

Description Batch

2 12 MS27039C1-08Screw

M 14185

36.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 NAS1515H3L

Washer

M 103481

FL2/

07/03/06 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 1:48:59 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24793A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3

m/103345

2-Install inserts & wearpads as per Dwg D3274. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearplates and skidtube

A/R Sikaflex-291

m/103497

Sikaflex expire date:

10/07

3-Install ring as per Dwg D3274

A/R Sikaflex-291

m/103497

Sikaflex expire date:

10/07

4-Inspect for foreign objects as per QSI 024

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

m/103497

Sikaflex expire date:

10/07

FR/

07/03/07

①

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20703-08 ②

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



u 07-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**RELEASED  
05-09-06

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. C SHEET 1 OF 4
DATE 05.03.16		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
9	9	D2648-3	WEARPAD
12	12	D2649	CROSS BOLT SPACER
1	1	D2656-15	WEARSHOE
1	1	D2656-23	WEARSHOE
1	1	D2656-35	WEARSHOE
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3287-1	WEARSHOE
1	1	D2646	AFT CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3429-1	WEARPAD
78	78	NAS1330C3KB116	INSERT
80	80	NAS1515H3L	WASHER
1	1	NAS1515H4	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
80	80	MS27039C1-08	SCREW
1	1	AN4C5A	BOLT

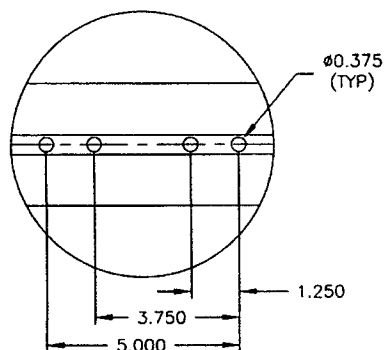
**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL 'E' (Ø0.250 REF) AND C'SINK Ø0.391x100° FOR NAS1330C3KB116 INSERT USING DT3274-1T2 BEFORE FINISH. INSTALL NAS1330C3KB116 INSERTS AFTER FINISH WITH LPS LABORATORIES "LPS-3".
8. WEARPLATES TO BE INSTALLED WITH A LAYER OF SIKAFLEX-241/-291 ADHESIVE BETWEEN WEARPLATES AND SKIDTUBE.
9. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DESGREASER.

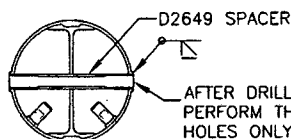
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# **DETAIL A: DRILL DETAIL**

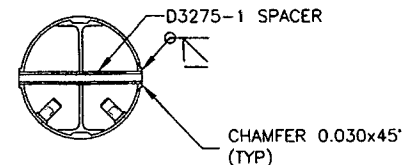


# **DETAIL B** FOR 0.375 HOLES ONLY

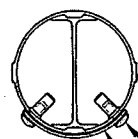


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

# **DETAIL C** FOR 0.313 HOLES ONLY

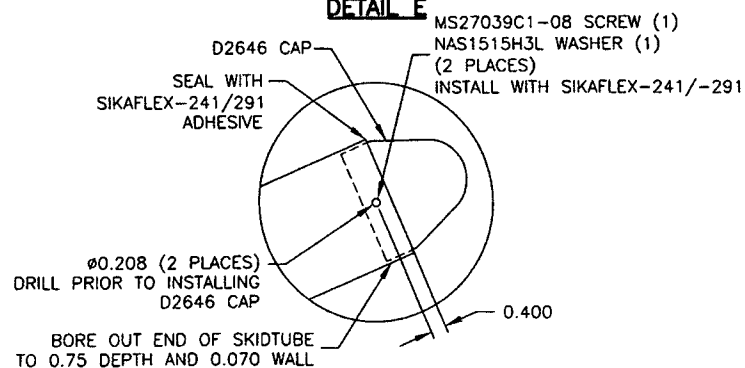


# **DETAIL D**

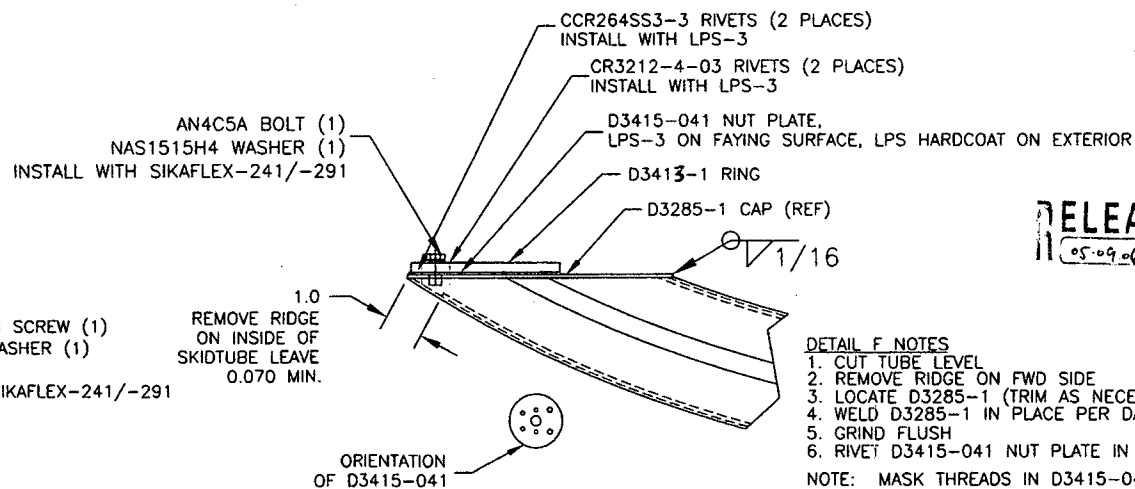


- NAS1330C3KB116 INSERT (1)  
MS27039C1-08 SCREW (1)  
NAS1515H3L WASHER (1)  
(78 PLACES)  
WEARPAD/WEARSHOE (REF)

# **DETAIL E**



# **DETAIL F: END FINISHING DETAIL**

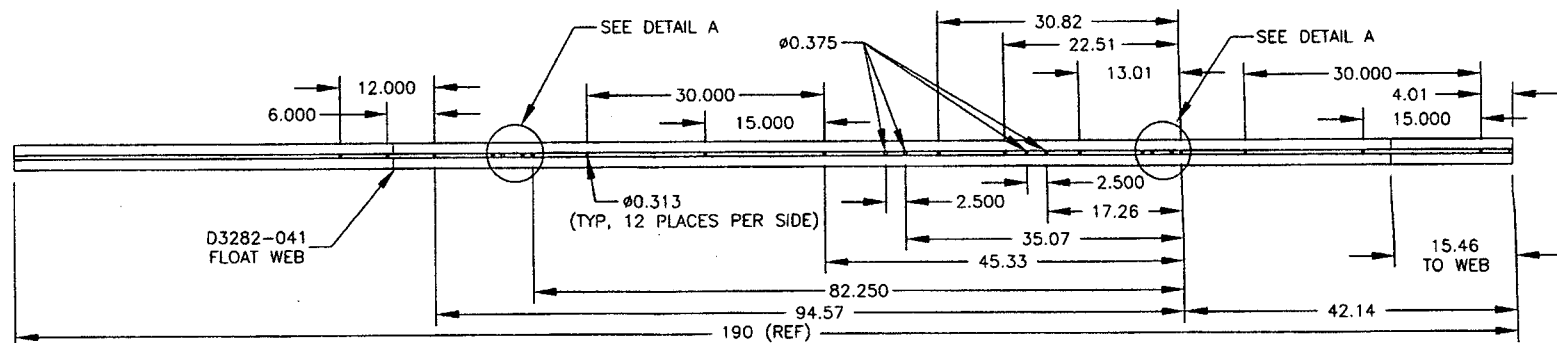


# **DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART OSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

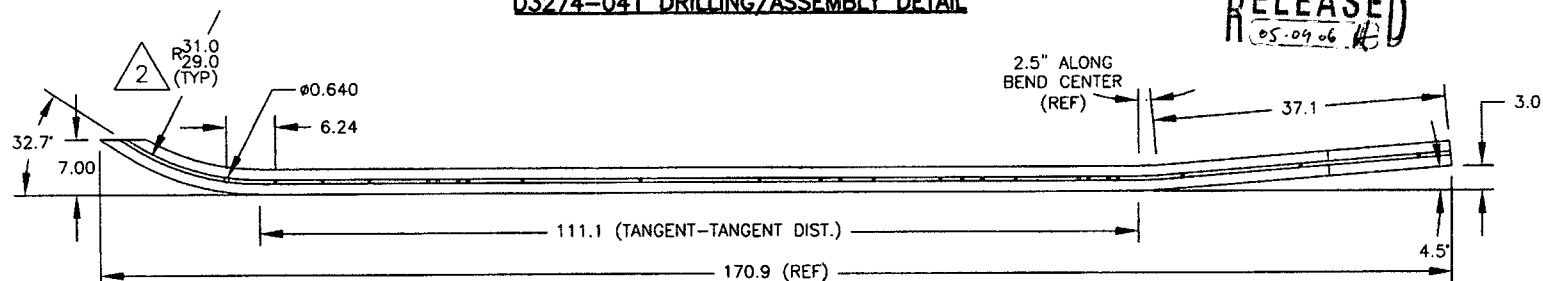
RELEASED  
05-09-06

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		DATE	05.03.16			TITLE SKIDTUBE ASSEMBLY	SCALE 1 TO 3

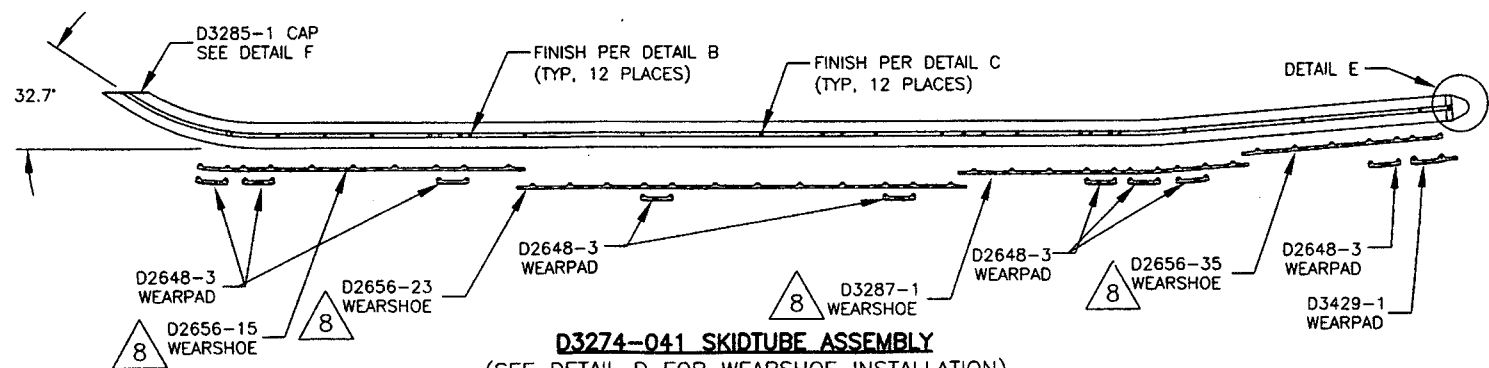


**D3274-041 DRILLING/ASSEMBLY DETAIL**

**RELEASED**  
05-09-06




**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DATE 05.03.16		DRAWING NO. D3274		SHEET 3 OF 4
		TITLE SKIDTUBE ASSEMBLY		SCALE 1:15

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	CHECKED	APPROVED		DRAWING NO.
	DATE	TITLE		SHEET 4 OF 4
	05.03.16	SKIDTUBE ASSEMBLY		1:15